

Work Order ID 78717

78717

Page 1

January-13-12 7:08:12 AM

Item ID: D3140-301 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 12/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 26/01/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/13 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3140	Rev F					(10)			
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3140 Dwg Rev: <u>F</u> Prog Rev: <u>F</u> 2-								
6661 - 067	Deburr if necessary								B12-8-16
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									B12-8-16
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

SMB
12-8-16

DAS
16
2-3 12/08/16

10 8 Pto

W/O: 78717		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: P 3140-301 PAR #: _____ Fault Category: Small FAI / Water Jet NCR: Yes No DQA: [Signature] Date: 12/08/30
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: _____

NCR: 121775		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/08/16	#100	Found at inspection that 24x8 Parts had nicks in the upper corner. 24. Parts were cracked too close together. on each end.	DAS 16 2-89 AS7042 12/08/16	SCRAP + Destroy 24x8 AND Recheck. M 121808	12-8-16 [Signature]	DAS 16 2-89 12/08/16	DAS 16 2-89 AS7042 12/08/16	DAS 16 2-89 02/08/16

NOTE: Date & initial all entries

78717

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/01/2012 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 26/01/2012 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

1-Scuff surfaces with 80grit sandpaper per QSI 0062-Deburr. No sharp edges

QC5- Inspect part completeness to step on W/O

0.00

140

0.00

QC

Memo

Quality Control

Chemical Conversion Coat per QSI005 4.1

0.00

150

0.00

HandFinish

Memo

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				10X	Ø		M-L 12/08/29
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>241A</u> Memo	0.00 0.00				10			SL 12/8/30
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MLJ 12/08/30 MF 12-08-30

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-13-12 7:08:21 AM

Page 1

Work Order ID: 78717

78717

Parent Item: D3140-301

D3140-301

Parent Item Name: Doubler

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A 02.11.06 New issue KJ/RF
 IPP Rev B 06.04.18 New dwg rev. ecn781 EC
 IPP rev.C 06.04.25 Waterjet EC
 IPP rev.D added scuffing NCR 061 EC
 IPP Rev:E As per ECN #829 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	162.0696	2.7777	29.23895			

M6061T6S 063

6061-T6 .063 Sheet

**

B12-8-16

Location

Loc Qty

Loc Code

MAT021

162.0695684

113608

0

116308

11.9555684

117285

75.414

119331

49.2

119802

25.5

121805

10

Dart Aerospace Ltd

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NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED H	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

UNCONTROLLED COPY
SUBJECT TO CHANGE
WITHOUT NOTICE
VIA E-MAIL
PO 78717 M.C.J
12/01/13

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1



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11-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Technical drawing of a boat hull cross-section, showing dimensions and part specifications. The drawing includes a side view of the hull and a detailed view of the interior structure.

Dimensions:

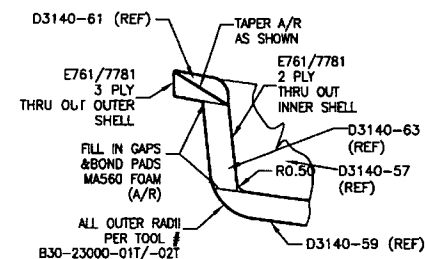
- Overall width: 76.50 (REF)
- Overall height: 48.75
- Interior width: 66.50 ± 0.25
- Interior height: 44.70
- Top edge width: 44.55 ± 0.25
- Top edge height: 21.30 ± 0.25
- Top edge width (right): 7.60 REF, 7.00 REF
- Top edge height (right): 6.50 REF, 25.2 REF
- Top edge width (left): 30.00 REF, 4.00 REF, 30.00 REF
- Top edge height (left): 28.40 2 PL REF, 23.525 2 PL REF
- Top edge width (bottom): 5.60 (REF), 5.00 (REF)
- Top edge height (bottom): 7.00 ± 0.080 0.000 (INSIDE), 6.00 REF, 1.50
- Top edge width (bottom right): 7.00 ± 0.080 0.000 (INSIDE)
- Top edge height (bottom right): 19.5 REF
- Top edge width (bottom left): 34.00 REF
- Top edge height (bottom left): 6.00 REF

Part Specifications:

- D3140-97 (-05) or D3140-98 (-06) BONDED TO DOOR E761/7781 OVER LAPPING 1.00" ± 0.25 ALL AROUND 2 PLY
- D3140-95 (3 PLACES) BONDED TO DOOR E761/7781 OVER LAPPING 1.00" ± 0.25 ALL AROUND 2 PLY
- D3140-61 (2 PLACES)
- D3140-87 BONDED INTO DOOR
- D3140-59 (REF)
- D3140-241
- D3140-61 (REF)
- D3140-59 (REF)
- D3140-63 (REF)

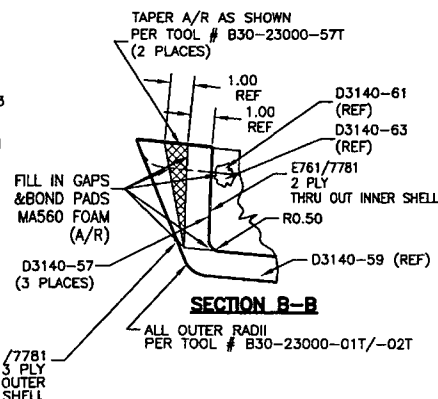
Notes:

- 11, 12 (Triangle symbols)
- A, B (Arrow symbols)
- R4.20 (8 PLACES, REF)
- R5.00 (8 PLACES, REF)
- 0.60 ± 0.080 0.000
- 0.80 REF



RELEASED

06.11.17



D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

1 2 3

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DESIGN	#	DRAWN BY	CB	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3140	REV. F SHEET 3 OF 7
DATE	06.10.06			TITLE DOOR	SCALE NITS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

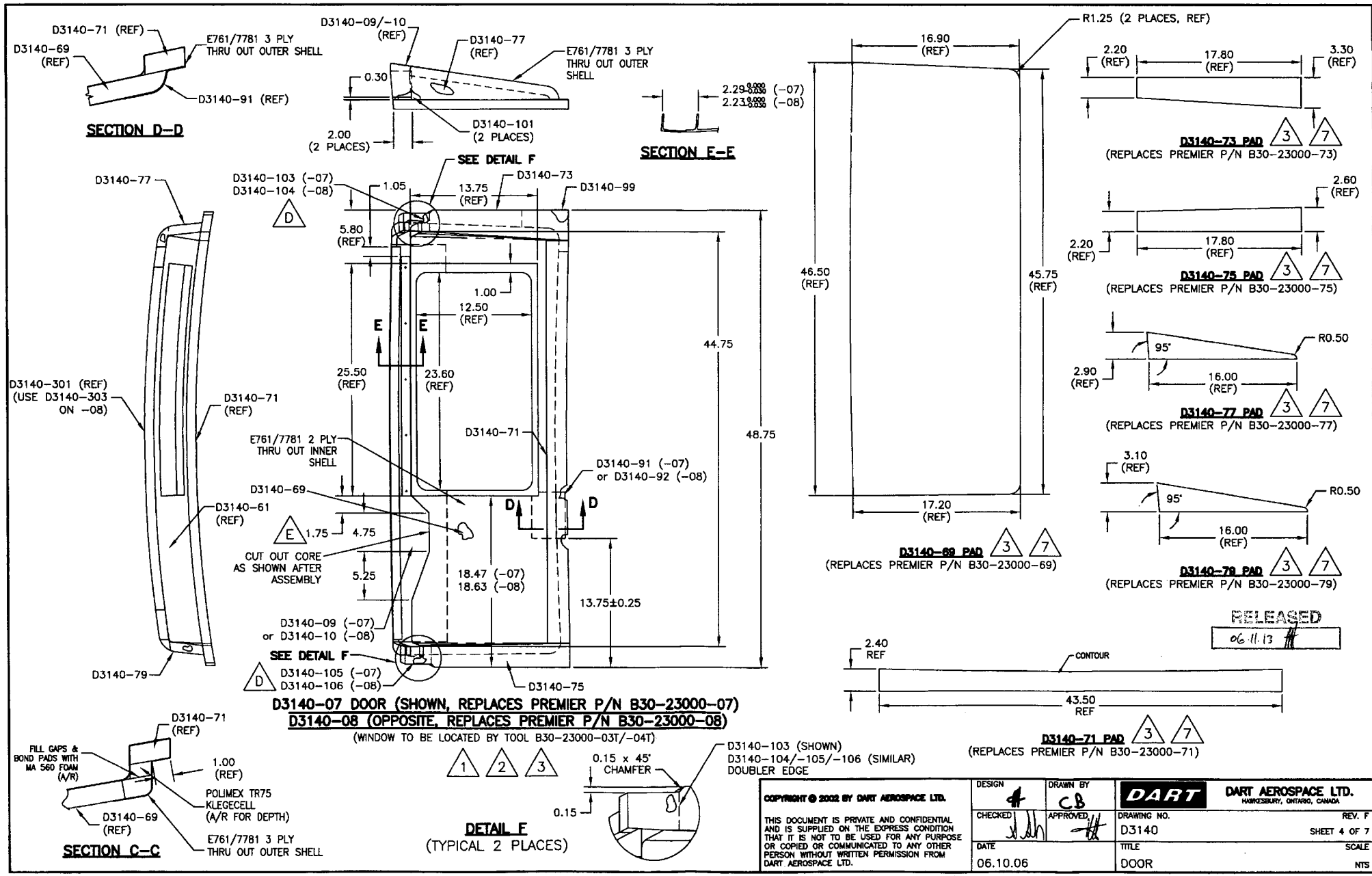
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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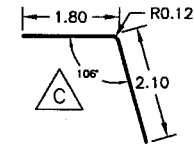
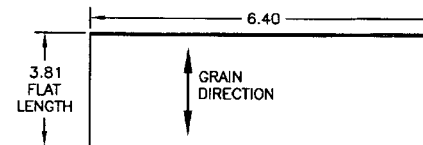
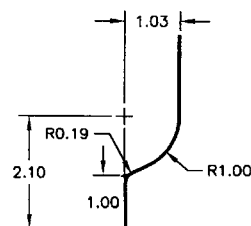
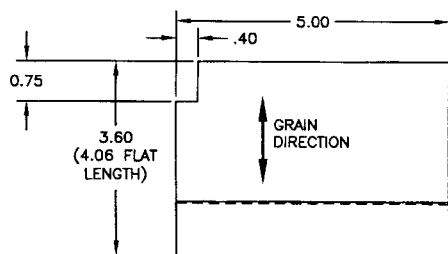
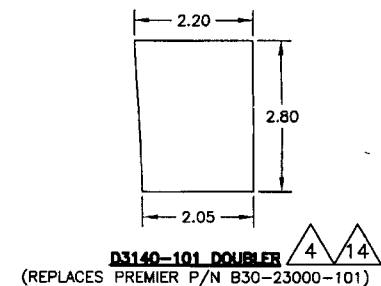
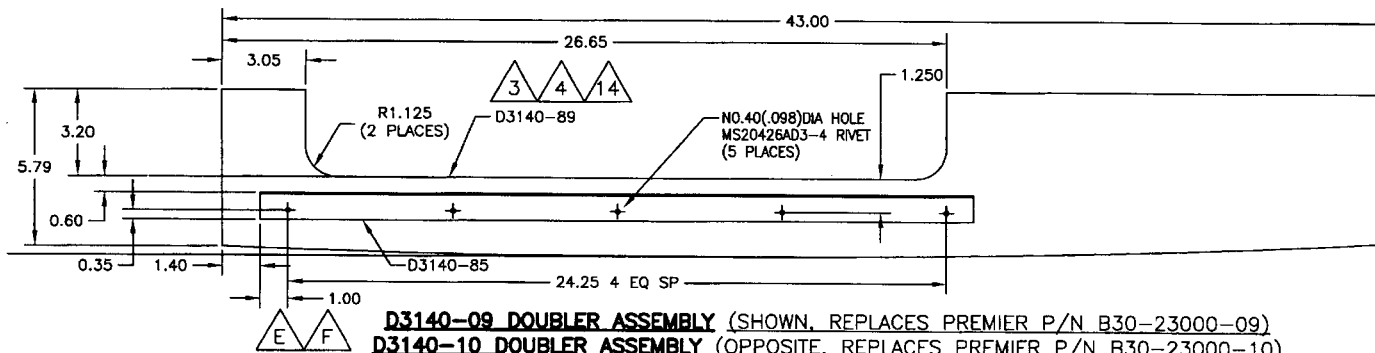
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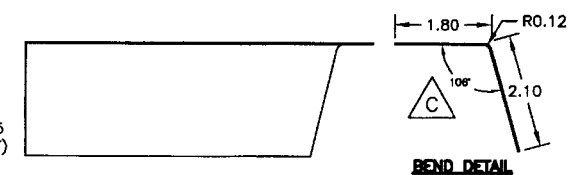
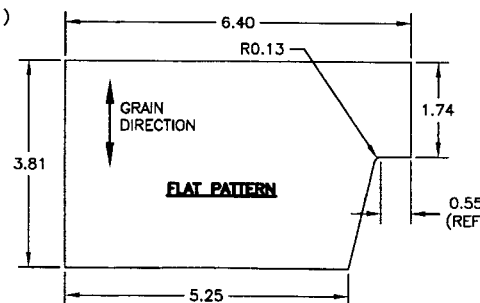
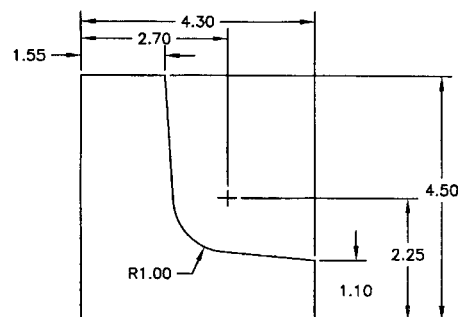
D3140-91F FLAT PATTERN
 (USE TO MAKE D3140-91/-92 DOUBLERS)

D3140-92 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-91)

D3140-95 DOUBLER (REPLACES PREMIER P/N B30-23000-95)

RELEASED

06.11.13



D3140-97 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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DESIGN 4	DRAWN BY CB	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED JH	APPROVED JH	DRAWING NO. D3140	REV. F SHEET 5 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	

W/O:		WORK ORDER CHANGES					
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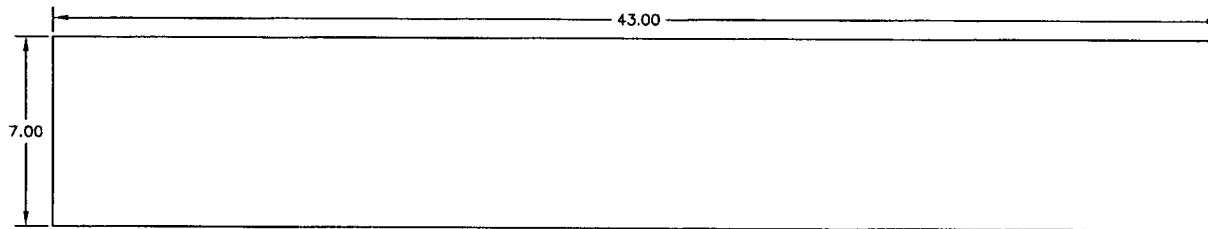
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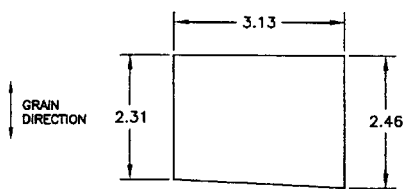
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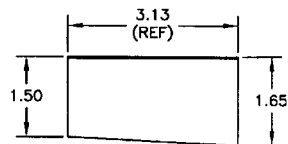
78717



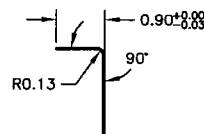
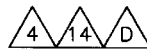
D3140-87 DOUBLER
(REPLACES PREMIER P/N B30-23000-87)



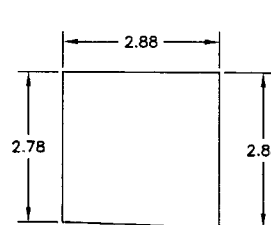
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



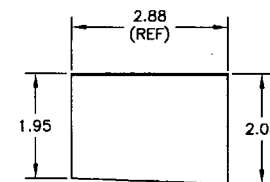
D3140-105 DOUBLER
D3140-106 OPPOSITE



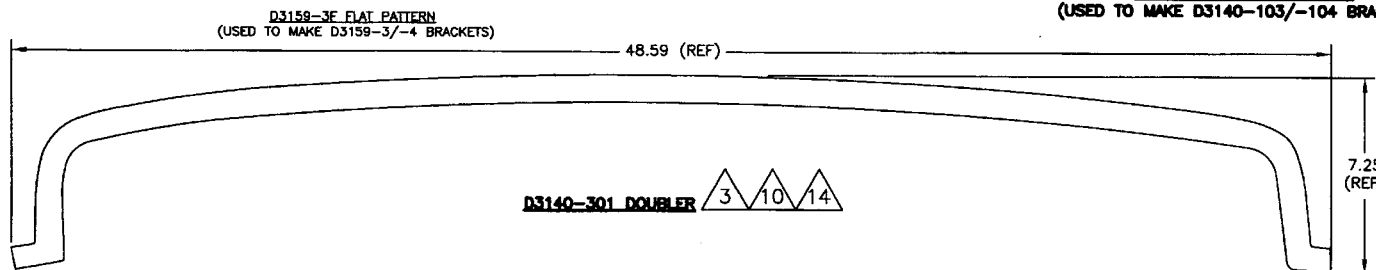
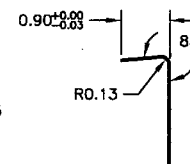
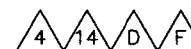
GRAIN
DIRECTION



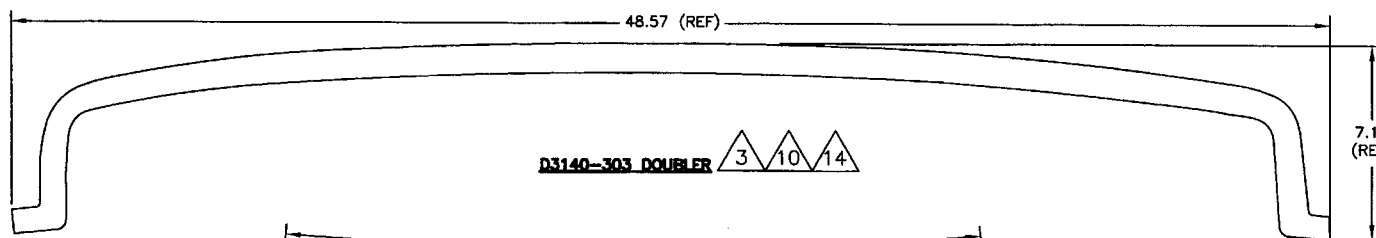
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



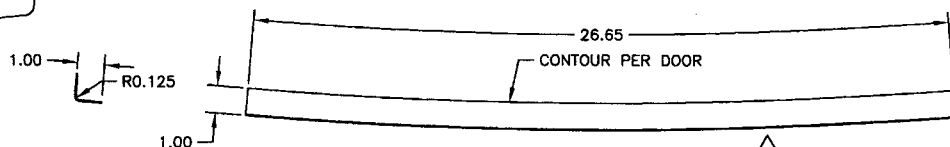
D3140-104 DOUBLER
D3140-103 OPPOSITE



D3140-301 DOUBLER



D3140-303 DOUBLER



D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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06.11.13

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CHECKED 	APPROVED 	DRAWING NO. D3140
DATE 06.10.06	TITLE DOOR	REV. F SHEET 6 OF 7 SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

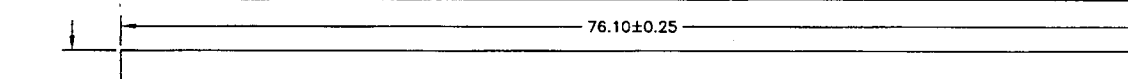
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

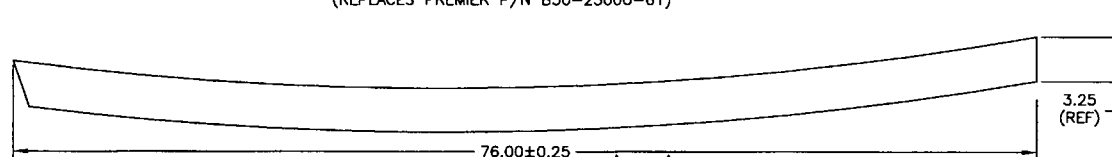
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

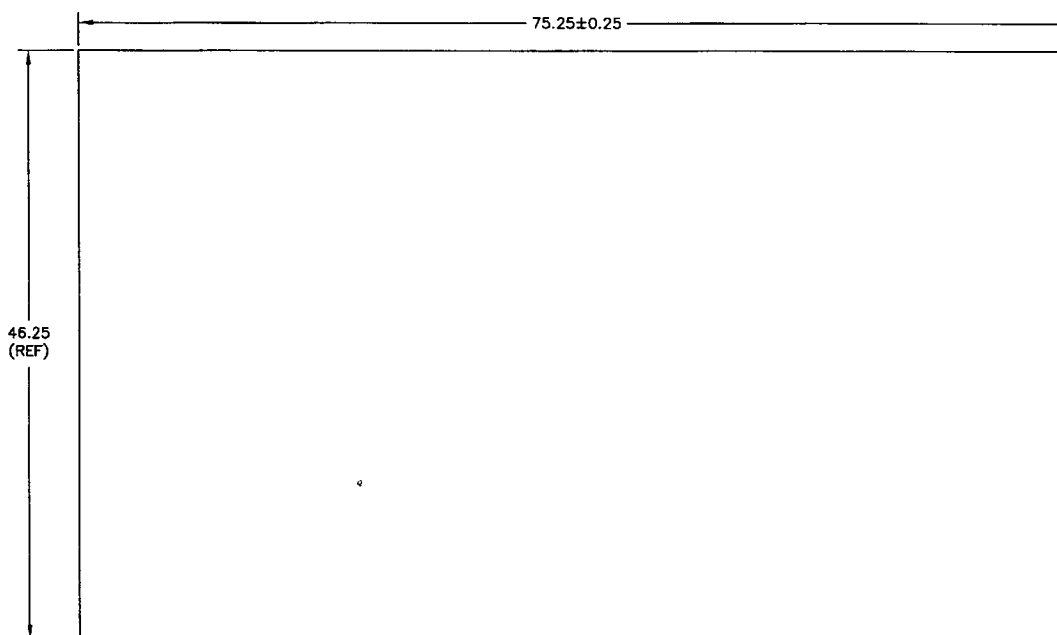
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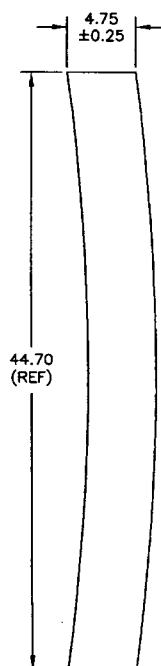
D3140-61 PAD 3 7
(REPLACES PREMIER P/N B30-23000-61)



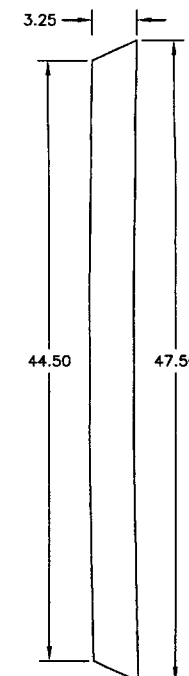
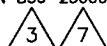
D3140-63 PAD 3 7
(REPLACES PREMIER P/N B30-23000-63)



D3140-59 PAD 7
(REPLACES PREMIER P/N B30-23000-59)



D3140-57 PAD
(REPLACES PREMIER P/N B30-23000-57)



D3140-241 DOUBLER 5 14
(REPLACES PREMIER P/N B30-23000-241)

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R1.00
(2 PLACES, REF)

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CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3140
DATE 06.10.06	TITLE DOOR	REV. F SHEET 7 OF 7
		SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries